

Work Order ID 50113

July 08, 2009 11:29:03 AM

Page 1

Item ID: D3564-3

Accept

Setup Start

Revision ID: D

Item Name: Wearshoe

Stop

Start Date: 7/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: D ☐ Prog

Rev: D ☐ 2-Deburr if necessary

B 9-7-07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 9-7-07

11

10

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

=> S09/07/07

10 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3564-3

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Stop

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Start Date: 7/10/2009 Start Qty: 10.00

Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179
and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

9/30/09/29 (11P)

140

QC5- Inspect part completeness to step on W/O

0.00

=> 509/02/09

(7/1) 0

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

150

0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch ☐ A/R 2059B Hardcoat
☐ Weld hardcoat as per Dwg D3437

M 11/2 001

EL 9-8-4

(ATT)

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Item ID: D3564-3 Accept Setup Start
Revision ID: D Stop
Item Name: Wearshoe
Start Date: 7/10/2009 Start Qty: 10.00 Cust Item ID:
Required Date: 7/31/2009 Req'd Qty: 10.00 Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00	27	8	08/08/04	(KC)			
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	27	8	02/08/04	(K)			
Quality Control									
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:20AM								

FINISH TIME: 7:50am

OVEN TEMPERATURE:

3209-

1109091

09-08-05

X11

JP

W/O:		WORK ORDER CHANGES					
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Page 4

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Revision ID: D
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Start Date: 7/10/2009 Start Qty: 10.00 Cust Item ID:
Required Date: 7/31/2009 Req'd Qty: 10.00 Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
	PK w Identify & stock FP-19								
210	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09-08-05 (11)

09-08-05 (11)

09-08-07

u 09.08.05

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

July 08, 2009 11:29:03 AM

Work Order ID: 50113

Parent Item: D3564-3RevD

Parent Item Name: Wearshoe

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	120.5511	11.5789			

304/316 Sheet .063

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

120.5510527

106860

17

111323

2.21

111924

101.341053

111924 1139-7-27

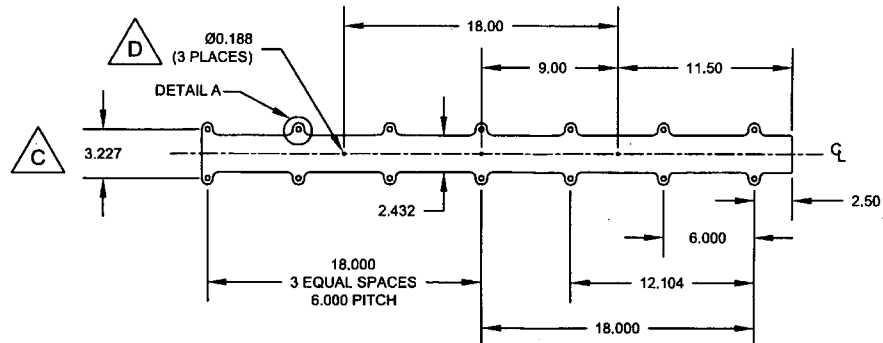
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

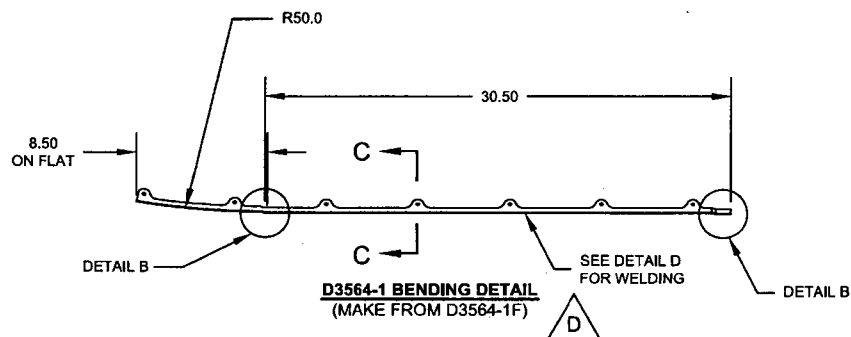
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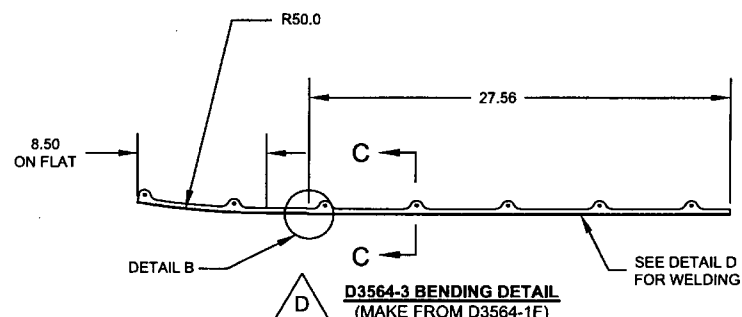
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

WLD SOLIC

RELEASED

07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
REV. D
SHEET 1 OF 3
TITLE WEARSHOE
SCALE 1:8

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RELEASED

07.09.04

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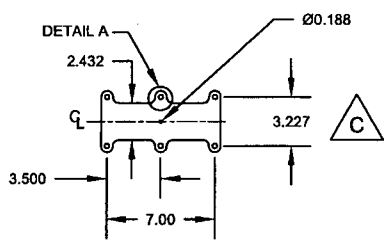
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

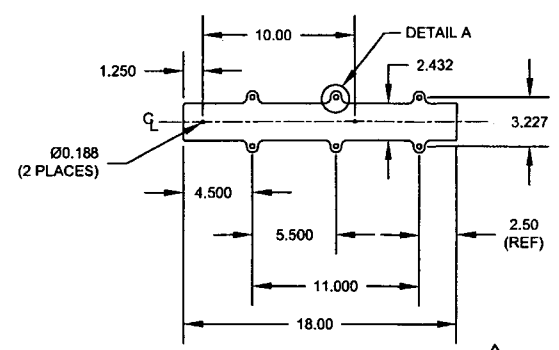
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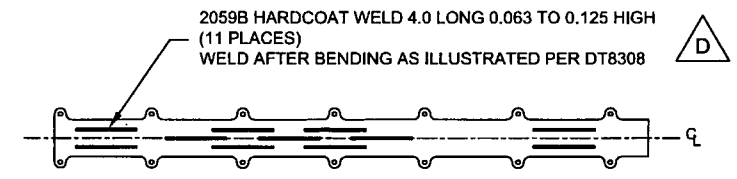
8 7 6 5 4 3 2 1



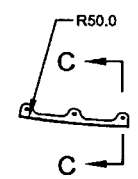
D3564-13F FLAT PATTERN



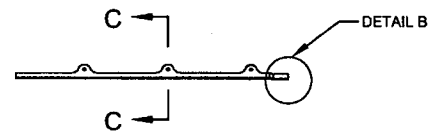
D3564-15F FLAT PATTERN



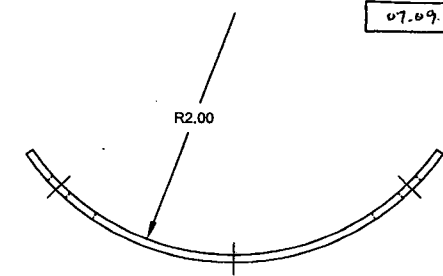
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



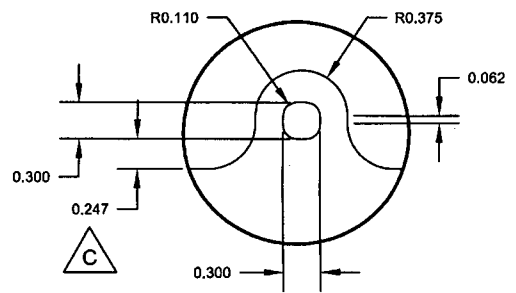
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



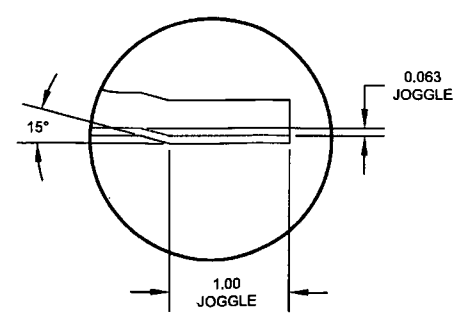
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

W/O 50113

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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DART AEROSPACE LTD		Work Order: 50113
Description: Wearshoe		Part Number: D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.230	✓			
2.432	+/-0.010	2.434	✓			
2.50	+/-0.030	2.501	✓			
6.000	+/-0.010	6.000	✓			
12.104	+/-0.010	12.104	✓			
18.000	+/-0.010	18.000	✓			
18.000	+/-0.010	18.000	✓			
18.00	+/-0.030	18.00	✓			
9.00	+/-0.030	9.00	✓			
11.50	+/-0.030	11.50	✓			
0.300 x 0.300	+/-0.010	0.303 x 0.305	✓			
Ø.188	+0.005/-0.001	.192	✓			
R0.375	+/-0.010	.375	✓			
0.063	+/-0.010	.062	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-7-07	Date: 02/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	